

Work Order ID 137040-2

\*137040\*

Page 1

Wednesday, September 23, 2015 11:52:02 A

Item ID: D135-692-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Bearpaw

Stop

\*NS2\*

Start Date: 9/23/2015 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 9/23/2015 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

MLS

Date: SEP 23 2015

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr     | Revision Nbr |
|--------------|--------------|
| D3049        | A1           |
| IIN-D135-692 | B            |

MLS

100 Document Control 0.00

\*100\*

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

MLS

SEP 23 2015

DAS

02

9-89

OCT 01 2015

150 Pick Kit 0.00

\*150\*

Packaging

Memo

0.00

Packaging

DAS

27

9-89

DAS

02

9-89

SEP 24 2015

Work Order ID 137040

\*137040\*

Page 2

Wednesday, September 23, 2015 11:52:02 A

Item ID: D135-692-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Bearpaw

Stop

\*NS2\*

Start Date: 9/23/2015 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 9/23/2015 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                               | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number            | Insp.<br>Stamp |
|--------------------------------|--------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|-----------------------------|----------------|
| 160                            | QC4- 100% Inspect kits for completeness                | 0.00                 |         |        |              |               |               |                             |                |
| <b>*160*</b>                   |                                                        |                      |         |        |              |               |               | DAS<br>6<br><del>9-39</del> |                |
| QC                             | Memo                                                   | 0.00                 |         |        |              |               |               |                             |                |
| Quality Control                |                                                        |                      |         |        |              |               |               |                             | OCT 02 2015    |
| 170                            | Packaging                                              | 0.00                 |         |        |              |               |               |                             |                |
| <b>*170*</b>                   |                                                        |                      |         |        |              |               |               | DAS<br>6<br><del>9-39</del> |                |
| Packaging                      | Memo                                                   | 0.00                 |         |        |              |               |               |                             | OCT 02 2015    |
| Packaging                      | Identify and pack for shipping as per PPP D135-692-011 |                      |         |        |              |               |               |                             |                |
|                                | Location: <u>613</u>                                   |                      |         |        |              |               |               |                             |                |
|                                | PPP Rev: _____                                         |                      |         |        |              |               |               |                             |                |
| 180                            | QC21- Final Inspection - Work Order Release            | 0.00                 |         |        |              |               |               |                             |                |
| <b>*180*</b>                   |                                                        |                      |         |        |              |               |               |                             |                |
| QC                             | Memo                                                   | 0.00                 |         |        |              |               |               |                             |                |
| Quality Control                |                                                        |                      |         |        |              |               |               |                             | OCT 02 2015    |

20151002

SH

# Picklist Print

Wednesday, September 23, 2015 11:52:05 AM

Page 1

Work Order ID: 137040

**\*137040\***

Parent Item: D135-692-011

**\*D135-692-011\***

Parent Item Name: Bearpaw

Start Date: 9/23/2015

Required Date: 9/23/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C04.02.17Blank size changed, Tolerance added Step  
3KJ/JLM IPP REV:E AS PER DSI  
9592/9587 REV A JLM VERIFIED BY:EC  
IPP Rev:D 08-04-16 Added Step 2 JLM Verified By:EC

| Component Item ID/<br>Item Name               | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit                                                                             | Total<br>Qty | Qty<br>Issued | Date<br>Issued    | Status            |
|-----------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------------------------------------------------------------------------------|--------------|---------------|-------------------|-------------------|
| AN4-13A<br>Bolt                               |                        | Purchased     | No          |                     |                  |                 | Each               | 202.0000       | 8    | 16           |               | DAS<br>27<br>9-89 | DAS<br>02<br>9-89 |
|                                               |                        |               |             |                     | <u>Location</u>  |                 |                    | <u>Loc Qty</u> | <u>Loc Code</u>                                                                         |              |               |                   |                   |
|                                               | DAS<br>6<br>9-89       |               |             |                     | FG               |                 |                    | 20             |                                                                                         |              |               |                   |                   |
|                                               |                        |               |             |                     | 122808           |                 |                    | 20             |                                                                                         |              |               |                   |                   |
|                                               |                        |               |             |                     | ST344            |                 |                    | 182            |                                                                                         |              |               |                   |                   |
|                                               |                        |               |             |                     | m132551          |                 |                    | 182            |                                                                                         |              |               |                   |                   |
| D2182B<br>Rubber Cushion - Black (\$Per Foot) |                        | Manufactured  | No          |                     |                  | 160             | f                  | 640.1768       | 2    | 4            |               | DAS<br>27<br>9-89 | DAS<br>02<br>9-89 |
|                                               |                        |               |             |                     | <u>Location</u>  |                 |                    | <u>Loc Qty</u> | <u>Loc Code</u>                                                                         |              |               |                   |                   |
|                                               | DAS<br>6<br>9-89       |               |             |                     | ST411            |                 |                    | 640.1768       |                                                                                         |              |               |                   |                   |
|                                               |                        |               |             |                     | 130427           |                 |                    | 290.1768       |                                                                                         |              |               |                   |                   |
|                                               |                        |               |             |                     | 135093           |                 |                    | 350            |                                                                                         |              |               |                   |                   |
| (D2182B060) Cut 4 at 6.00"                    |                        |               |             |                     |                  |                 |                    |                |                                                                                         |              |               |                   |                   |
| D2274<br>Radius Block                         |                        | Manufactured  | No          |                     |                  | 160             | Each               | 116.0000       | 8  | 16           |               | DAS<br>27<br>9-89 | DAS<br>02<br>9-89 |
|                                               |                        |               |             |                     | <u>Location</u>  |                 |                    | <u>Loc Qty</u> | <u>Loc Code</u>                                                                         |              |               |                   |                   |
|                                               | DAS<br>6<br>9-89       |               |             |                     | FG               |                 |                    | 12             |                                                                                         |              |               |                   |                   |
|                                               |                        |               |             |                     | 86855            |                 |                    | 12             |                                                                                         |              |               |                   |                   |
|                                               |                        |               |             |                     | ST006            |                 |                    | 104            |                                                                                         |              |               |                   |                   |
|                                               |                        |               |             |                     | 134217           |                 |                    | 104            |                                                                                         |              |               |                   |                   |

SEP 24 2015

# Picklist Print

Wednesday, September 23, 2015 11:52:05 AM

Page 2

Work Order ID: 137040

**\*137040\***

Parent Item: D135-692-011

**\*D135-692-011\***

Parent Item Name: Bearpaw

Start Date: 9/23/2015

Required Date: 9/23/2015

Start Qty: 2.00

Required Qty: 2.00

D2519

Manufactured No

160

Each

6.0000

8

**\*D2519\***

Clamp

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST542

6

137051

DAS  
27  
9-89

DAS  
02  
9-89

134298

6

D2529

Manufactured No

160

Each

315.0000

16

**\*D2529\***

Washer

DAS  
6  
9-89

Location

Loc Qty

Loc Code

ST007

115

131945

115

ST008

200

135846

100

136774

100

D3049-1

Manufactured No

160

Each

0.0000

4

**\*D3049-1\***

Bearpaw

DAS  
6  
9-89

\*\*

DAS  
27  
9-89

DAS  
02  
9-89

SEP 24 2015

B136487 4

# Picklist Print

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Page 3

Work Order ID: 137040

**\*137040\***

Parent Item: D135-692-011

**\*D135-692-011\***

Parent Item Name: Bearpaw

Start Date: 9/23/2015

Required Date: 9/23/2015

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

160

Each

1,671.000

8

16

**\*MS21042L4\***

Locknut

**\*\***

DAS  
27  
9-89

DAS  
02  
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

112

m127813

112

ST260a

170

m130799

56

m131803

6

m132262

108

ST305

1387

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

m132382

1207

16

NAS1149D0463J

Purchased

No

160

Each

2,569.000

8

16

**\*NAS1149D0463J\***

WASHER

**\*\***

DAS  
02  
9-89

Location

Loc Qty

Loc Code

GA

41

M129390

41

ST260a

1000

M133077

1000

ST269

1528

M129682

86

M130799

371

M132035

58

M132317

125

M132677

888

16

DAS  
27  
9-89

SEP 24 2015

Wednesday, September 23, 2015 11:52:05 AM

Shop Packet Print

DAS  
27  
9-89

Page 3

# Picklist Print

Wednesday, September 23, 2015 11:52:05 AM

Page 4

Work Order ID: 137040

\*137040\*

Parent Item: D135-692-011

\*D135-692-011\*

Parent Item Name: Bearpaw

Start Date: 9/23/2015

Required Date: 9/23/2015

QS100-M24S

Purchased

No

160

Each

11.0000

Start Qty: 2.00

Required Qty: 2.00

\*QS100-M24S\*

Clamp

\*\*

DAS

DAS

27

02

9-89

9-89

SEP 24 2015

Location

Loc Qty

Loc Code

ST544

11

m133134

11

8

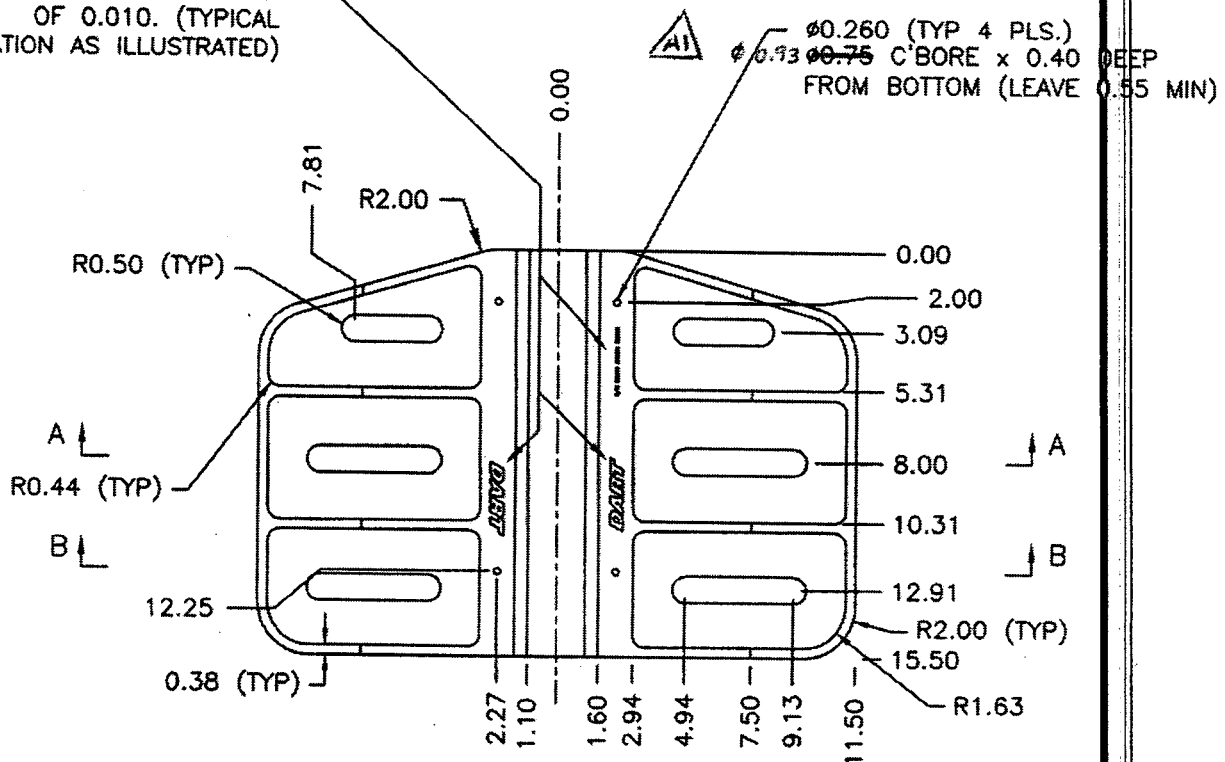
DAS  
6  
9-89



|                  |                  |                                                   |                        |
|------------------|------------------|---------------------------------------------------|------------------------|
| DESIGN<br>RF     | DRAWN BY<br>RF   | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br>#    | DRAWING NO.<br>D3049                              | REV. A<br>SHEET 1 OF 2 |
| DATE<br>01 10.18 | TITLE<br>BEARPAW |                                                   | SCALE<br>1:7           |
| A                | 01.10.18         | NEW ISSUE                                         |                        |
| AI               | # RF 03.01.13    | Ø 0.93 WAS Ø 0.75                                 |                        |

RELEASED  
01.10.24

ENGRAVE DART LOGO TO  
MAX DEPTH OF 0.012.  
ENGRAVE PART AND BATCH  
NUMBERS TO MAX DEPTH  
OF 0.010. (TYPICAL  
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

137040 MJS  
1504-23

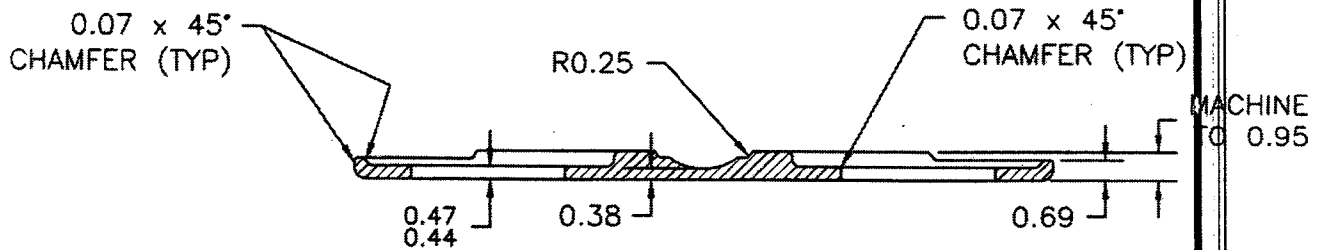
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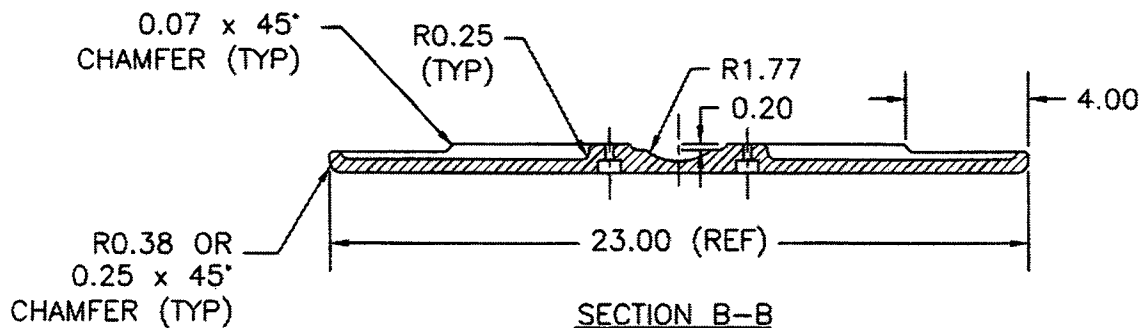


|                  |                |                                                   |              |
|------------------|----------------|---------------------------------------------------|--------------|
| DESIGN<br>RF     | DRAWN BY<br>RF | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |              |
| CHECKED<br>#     | APPROVED<br>#  | DRAWING NO.<br>D3049                              | REV. A       |
| DATE<br>01.10.18 |                | TITLE<br>BEARPAW                                  | SHEET 2 OF 2 |
|                  |                |                                                   | SCALE<br>1:6 |

RELEASED  
01.10.24



SECTION A-A



SECTION B-B

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DAS  
8-89  
REFERENCE ONLY

OCT 01 2015

**4. WEIGHT AND BALANCE**

| Installation                                                     | Weight             | LATERAL         |                       | LONGITUDINAL       |                         |
|------------------------------------------------------------------|--------------------|-----------------|-----------------------|--------------------|-------------------------|
|                                                                  |                    | Arm             | Moment                | Arm                | Moment                  |
| <b>D135-692-011</b><br><i>Bearpaw Installation</i>               | 11.8 lb<br>5.36 kg | 0.0 in<br>0.0 m | 0.0 in-lb<br>0.0 m-kg | 199.7 in<br>5.07 m | 2356 in-lb<br>27.2 m-kg |
| <b>D135-692-041</b><br><i>Wearplate Kit</i>                      | 2.24 lb<br>1.0 kg  | 0.0 in<br>0.0 m | 0.0 in-lb<br>0.0 m-kg | 199.7 in<br>5.07 m | 447 in-lb<br>5.1 m-kg   |
| <b>D135-692-011</b><br><i>Bearpaw Installation, Aft Location</i> | 11.8 lb<br>5.36 kg | 0.0 in<br>0.0 m | 0.0 in-lb<br>0.0 m-kg | 201 in<br>5.10 m   | 2372 in-lb<br>27.3 m-kg |
| <b>D135-692-041</b><br><i>Wearplate Kit, Aft Location</i>        | 2.24 lb<br>1.0 kg  | 0.0 in<br>0.0 m | 0.0 in-lb<br>0.0 m-kg | 201 in<br>5.10 m   | 450 in-lb<br>5.1 m-kg   |

**5. PARTS LIST**

| Qty<br>-011 | Qty<br>-041 | Part Number   | Description          |
|-------------|-------------|---------------|----------------------|
| X           |             | D135-692-011  | BEARPAW INSTALLATION |
|             | X           | D135-692-041  | WEARPLATE KIT        |
| (4)         |             | D2182B060     | RUBBER CUSHION       |
| 8           |             | D2274         | RADIUS BLOCK         |
| 2           |             | D3049-1       | BEARPAW              |
| 8           |             | D2529         | WASHER               |
| (4)         |             | D2519         | CLAMP                |
|             | 2           | D3719-041     | WEARPLATE            |
| (8)         | 8           | AN4-13A       | BOLT                 |
| 8           | 8           | NAS1149D0463J | WASHERS              |
| 8           | 8           | MS21042L4     | NUT (OR MS21042-4)   |
| (4)         |             | QS100M24S     | CLAMP                |

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Revision: **B**

Date: 15.07.20